



Dart Aerospace Ltd.
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D2012-105
Job Sheet 212072



Part No: D2012-105

Job Qty: 3 pcs

Part Name: Arm (31.06)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/5/20

Job Tracking No:

Due Date: 8/24/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV E IPP Rev:I 02.04.03 Added Inspect level 3 NG

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - Brake NC	3 pcs	8/22/20		0.25	0.85	Small Fab - Brake - 1		
							Small Fab - Brake - 2		MLL 12/10/20
							Small Fab - Brake - 3		
110	Small Fab - 2 - B4B	3 pcs	8/22/20		0.00	0.55	Small Fab - 1 - B4B		
							Small Fab - 2 - B4B		MLL 12/10/20
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		
							Small Fab - 6 - B4B		
							Small Fab - 7 - B4B		
							Small Fab - 8 - B4B		
							Small Fab - 9 - B4B		
120	QC 5	3 pcs	8/22/20		0.00	0.00	Small Fab - Various 1 - B4B		
							QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		



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Container No: S319685



Part: D2012-105

Job No: 212072

Serial No/Batch: S319685

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 12/10/20

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130 Powdercoat - 4 Black Sand - B4B	3 pcs	8/24/20	0.00 0.11	QC 5 - 61	
				QC 5 - 81	DEC 10 2020
				QC 5 - 82	0202 01 336
				Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	20-12-16
				Powdercoat - 4 - B4B	
				Powdercoat - 5 - B4B	
				Powdercoat - 6 - B4B	
				Powdercoat - 7 - B4B	
				Powdercoat - 8 - B4B	
140 QC 3	3 pcs	8/24/20	0.00 0.00	Powdercoat - 9 - B4B	
				Powdercoat - 10 - B4B	
				QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	DEC 17 2020
				QC 3 - 19	40
150 Packaging 3-1 - Stock - B4B	3 pcs	8/24/20	0.00 0.00	QC 3 - 43	9-89
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
				QC 3 - 82	
				QC 3 - 87	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	DAS
				Packaging 3 - 6 - B4B	28
				Packaging 3 - 7 - B4B	9-89
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	DEC 17 2020
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	

				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
160 QC 21 - SA	3	8/24/20	0.00 0.00	QC 21 - SA - 21	DAS
	pcs			QC 21 - SA - 70	21
				QC 21 - SA - 9	9-89
				QC 21 - SA - 77	DEC 18 2020

Part Op **100** - (Bend/Assemble as per dwg) Punch to length as per Dwg D2012-105 & template D2012-105T1 and DT8116 Use
 Descriptions: DT10255 TO CHECK PART
110 - (Small Fab) 1-Debur
120 - (QC5- Inspect part completeness to step on W/O) Use DT10255 TO CHECK PART
130 - (Black Sandtex (Ref:4.3.5.7) per QSI005 4.3) START TIME: 10:15 OVEN TEMPERATURE: 320°
 FINISH TIME: 10:30
140 - (QC3- Inspect Part Finish)
150 - (Identify as per dwg & Stock Location: _____)
160 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304TR0.500W.035	304 Round Tube .500 X .035W	7.8762 ft (2.6254 ea)	100-Small Fab - Brake NC	5317145

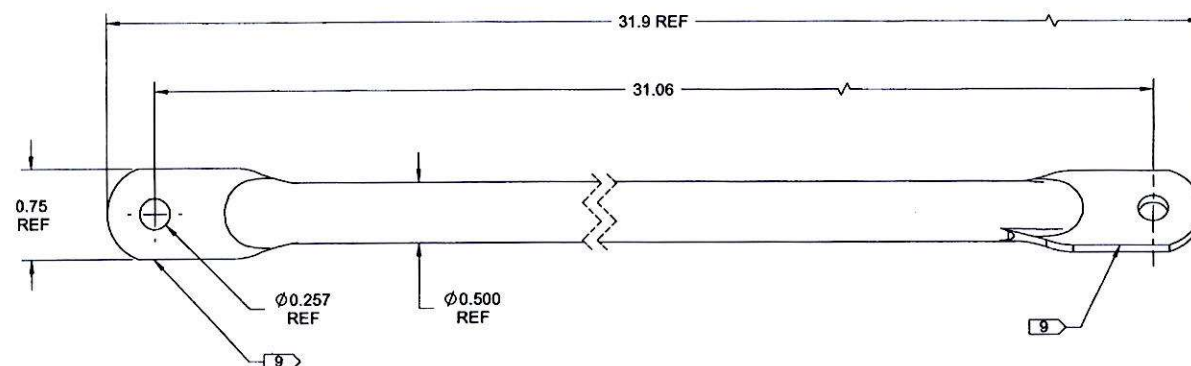
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - Brake NC	M304TR0.500W.035	8	107	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Arm	31.900inches ± 0.030	31.930 31.870		
2	Arm	31.060Inches ± 0.030	31.090 31.030		
3	Arm	0.257Inches + 0.006 - 0.001	0.263 0.256		

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D2012-105 ARM

NOTES:

- 1) MATERIAL: AISI 304/316 SS TUBE $\phi 0.500 \times 0.035$ WALL PER ASTM A213/A269 OR ASME A213 (REF DART SPEC. M304TR0500W.035)
- 2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2012-105" USING REMOVABLE TAG
- 7) WEIGHT: 0.47 lbs
- 8) MAKE PER TEMPLATE DT8116
- 9) PUNCH BOTH ENDS PER SPEC CONTROL DWG D2727

E	REFORMAT DWG, ANGLE DIMENSION POSITION AND VALUE CHG: 35° WAS 30° (ZN C2-1), PER NCR 09-080	CP	09.06.04
D	ADDED TEMPLATE & SPEC CNTRL DWG, REDRAWN IN CAD, ADD FINISH	KE	98.04.28
C	CORRECTED VIEWS PER TSR A374	KE	97.09.03
B	30° ANGLE ROTATED 60° CCW	JB	96.06.25
A	NEW ISSUE, DRAWN FROM D2012	H	92.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2012-105 REV. E TITLE ARM SCALE NTS DATE 09.06.04	
DRAWN	JB		
CHECKED	JB		
MFG. APPR.	JB		
APPROVED	JB		
DE APPR.	JB	COPYRIGHT © 1992 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	